

Work Order ID 144079

Friday, April 01, 2016 9:09:16 AM

144079

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Item ID: D2576-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step (Casting Detail)
Start Date: 4/1/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 4/15/2016 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2576	Rev G								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>31901</u> Cast per D2576-1 Pattern vendor: Alpine Non-Ferrous Material Release Note Required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.02							
Packaging	Ensure D2576 mould is returned with the ordered parts. Ensure release note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

APR 01 2016

DAS
13
9-88

50x Sp/6-ex-25

50

DAS
38
APR 20 2016

Work Order ID 144079***144079***

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Friday, April 01, 2016 9:09:16 AM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location	0.00							
130									
Packaging	Memo	0.01							DAS 6 9-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.08							
Quality Control									

SO APR 27 2016

MCS APR 27 2016

MCS APR 27 2016

Picklist Print

Page 1

- Friday, April 01, 2016 9:09:15 AM

Work Order ID: 144079

144079

Parent Item: D2576-1

D2576-1

Parent Item Name: Step (Casting Detail)

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 50.00

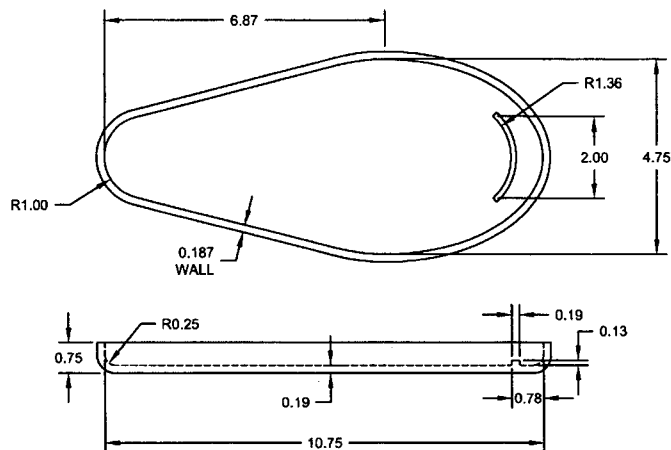
Required Qty: 50.00

Comments: IPP Rev: A New Issue 05-11-29 JLM
 IPP rev B rev F dwg 07.07.06 EC
 IPP Rev:C As per Rev G 07-09-05 JLM Verified By:EC

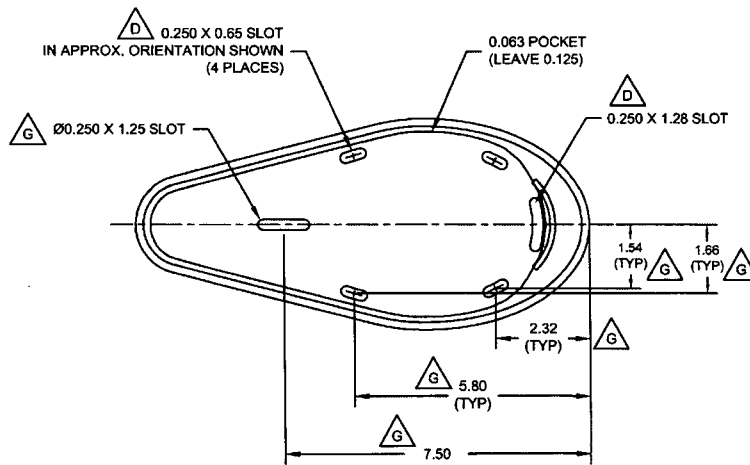
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2576-1P		Purchased	No			100	Each	0.0000	1	50			
D2576-1P									**				
Step (Casting Detail)													

50x 2016-04-29



D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

RELEASED

07.08.29

G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	1		
CHECKED	PH	DRAWING NO.	REV. G
MFG. APPR.	PH	D2576	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	STEP	1:3
DATE	07.08.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31901

Purchase Order Date 4/1/2016 9:18:13 AM

PO Print Date 4/1/2016

Page Number 1 of 2

Order From :
ALPINE NON-FERROUS FOUNDRY
8657 - 132ND STREET
SURREY, BC V3W 4P1
CA

VC-ALP001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

APR 01 2016

Contact Name
Vendor Phone 604 596 8080

Ship To Contact
Ship To Phone
Ship Via: FedEx PI collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D2576-1P	Step (Casting Detail)	4/22/2016 Yes 4/22/2016		50.00 Each	\$17.75	\$887.50
	AS PER DWG D2576 REV. G B144079 ✓						
	Line Total:						\$887.50
2	71401-45	PROCUREMENT QUALITY CLAUSES	4/22/2016 No 4/22/2016		1.00	\$0.00	\$0.00
	PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS						

please advise delivery
on p/o: 31901. thanks Chantal.

Note:

e-mail: clavoie@dartaero.com.

ALPINE NON-FERROUS FOUNDRY

8657-132ND STREET
SURREY, B.C. V3W 4P1
CANADA

PACKING LIST
WORK ORDER

Order No.: PO31901
Date: 01 Apr, 2016
Page: 1
Ship Date: 21 Apr, 2016

Sold To:

DART AEROSPACE

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To:

DART AEROSPACE

Order Date	Purchase Order#	Due Date	Ship Via	Page
01 Apr, 2016	PO31901	21 Apr, 2016	FEDEX	1
Item No.	Description	Ordered	Backorder quantity	Shipped quantity
DART D2576	D2576 STEP CSTG GS - GST @ 5% GST PST Exempt: #6122-5207	50	50	50
ALPINE NON-FERROUS FOUNDRY GST: #87550 0001				

Sp/6-04-25

Comment: Castings&Patterns are property of Alpine until paid in full

SIEMEX CORPORATION
8F, No. 110, Sec. 2, Keelung Road,
Taipei City 10695, Taiwan, R. O. C.

CERTIFICATE OF ANALYSIS

Alloy: 535.2

Heat # 104121101

	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn
	%	%	%	%	%	%	%	%
1	0.0374	0.0770	< 0.00010	0.165	6.83	0.0019	0.0032	< 0.00060
2	0.0446	0.0847	0.00081	0.168	6.98	0.0021	0.0044	< 0.00060
3	0.0334	0.0795	< 0.00010	0.158	6.64	0.0019	0.0032	< 0.00060

	Ti	Ca	Na	Pb	Sb	Sn	Sr	Al
	%	%	%	%	%	%	%	%
1	0.170	0.00082	0.00029	0.0013	< 0.00040	0.0012	< 0.00010	92.7
2	0.166	0.00060	0.00029	0.0013	< 0.00040	0.0011	< 0.00010	92.5
3	0.183	0.00065	0.00038	0.0012	< 0.00040	0.0011	< 0.00010	92.9

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST ORE ARE TRACEABLE TO NIST.

SIEMEX CORPORATION



WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.